

Date: Wednesday, 22/10/2008 8:20:20 AM  
 User: Julie Dawson

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	02.500 SUPPORT		
Job Number	42785		Part Number	D28921		
Estimate Number	11058		Drawing Number	D2892 REV A		
P.O. Number	:		Project Number	N/A		
This Issue	22/10/2008	S.O. No. :	Drawing Revision	A		
Prsht Rev.	NC		Material	:		
First Issue	/ /	Type : MACHINED PARTS	Due Date	29/10/2008	Qty:	20
Previous Run	41986		Um:	Each		
Written By	:					
Checked & Approved By	<u>JL 08/10/22</u>					
Comment	Est. C 02.11.26 Added P/O KJ Est. D 08.03.19 Re-format EC verified by: DD					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DSK077	D2892-1 TURNING DETAIL	
		Comment: Qty.: 0.5000 Each(s)/Unit Total : 10.0000 Each(s) D2892-1 TURNING DETAIL Batch: <u>B42245</u>	<u>JL 08/11/26</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS Machine as per Folio FA082 Tumble & Deburr	<u>JL mnf 08/11/27</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>JL mnf 08/11/27</u>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>MNL 08/12/02 20</u>
5.0	POWDER COATING	POWDER COATING	 <u>M 109152</u> <u>20X</u>
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3	
	START TIME:	<u>9:00</u>	
	OVEN TEMPERATURE:	<u>400° F</u>	
	FINISH TIME:	<u>9:30</u>	<u>MNL 08/12/08</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 22/10/2008 8:20:20 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.500 SUPPORT

Job Number: 42785

Part Number: D28921

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



g10



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-08

(2008)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: X tube assy

RT 09-02-08

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 09-02-26

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42785
Description: Ø2.500 Support	Part Number:	D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article     Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.115	0.135		.132	.132	.136	.131	.135
AB	0.290	0.310		.310	.310	.310	.310	.304
AC	0.040	0.060		.044	.044	.043	.043	.041
AD	0.115	0.135		.126	.126	.126	.127	.127
AE	0.240	0.260		.248	.247	.250	.247	.246
AF	0.188	0.193		.190	.190	.190	.190	.190
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.140	1.140	1.139	1.142	1.143
AI	0.454	0.474		.464	.464	.455	.456	.458
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.261	.261	.261	.261	.261
AM	1.663	1.683		1.672	1.672	1.669	1.668	1.668
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.783	2.785	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: JL mm Date: 08/11/27

Audited by: CMF Date: 08/12/02

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	JL
B	08.04.21	Reformat	KJ/JLM	JL

DART AEROSPACE LTD	Work Order:	42785
Description: Ø2.500 Support	Part Number:	D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article     Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	20
HAAS Section								
AA	0.115	0.135		.134	.134	.134	.134	.134
AB	0.290	0.310		.305	.307	.305	.310	.310
AC	0.040	0.060		.043	.042	.044	.044	.042
AD	0.115	0.135		.127	.128	.125	.127	.127
AE	0.240	0.260		.246	.244	.243	.247	.243
AF	0.188	0.193		.190	.190	.190	.190	.190
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.149	1.148	1.142	1.145	1.142
AI	0.454	0.474		.458	.461	.462	.463	.463
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.260	.260	.261	.260	.260
AM	1.663	1.683		1.669	1.668	1.666	1.672	1.671
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.783	2.782	2.782	2.783	2.781
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: MNF Date: 08/11/07

Audited by: JMK Date: 08/12/02

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	JM
B	08.04.21	Reformat	KJ/JLM	JM

DART AEROSPACE LTD	Work Order:	42785
Description: Ø2.500 Support	Part Number:	D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article     Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
HAAS Section								
AA	0.115	0.135		.184	.134	.133	.135	.134
AB	0.290	0.310		.340	.310	.310	.310	.310
AC	0.040	0.060		.045	.044	.045	.046	.043
AD	0.115	0.135		.126	.127	.125	.125	.133
AE	0.240	0.260		.244	.250	.250	.246	.246
AF	0.188	0.193		.190	.190	.190	.190	.190
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.139	1.140	1.140	1.141	1.140
AI	0.454	0.474		.459	.460	.463	.460	.458
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.261	.260	.260	.260	.260
AM	1.663	1.683		1.667	1.667	1.667	1.667	1.668
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.782	2.783	2.782	2.781
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: MML Date: 08/11/28

Audited by: mk Date: 08/12/02

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	<u>jk</u>
B	08.04.21	Reformat	KJ/JLM	<u>jk</u>

DART AEROSPACE LTD		Work Order:	42785
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892 Rev: A			Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article     Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	20
HAAS Section								
AA	0.115	0.135		.134	.134	.133	.133	.133
AB	0.290	0.310		.310	.310	.310	.310	.310
AC	0.040	0.060		.045	.044	.044	.045	.043
AD	0.115	0.135		.128	.127	.131	.132	.132
AE	0.240	0.260		.251	.250	.249	.244	.244
AF	0.188	0.193		.190	.190	.190	.190	.190
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.139	1.139	1.142	1.140	1.139
AI	0.454	0.474		.463	.463	.456	.461	.458
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.261	.261	.261	.261	.261
AM	1.663	1.683		1.667	1.669	1.667	1.669	1.669
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.783	2.783	2.780	2.783	2.782
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: MRC Date: 08/11/20

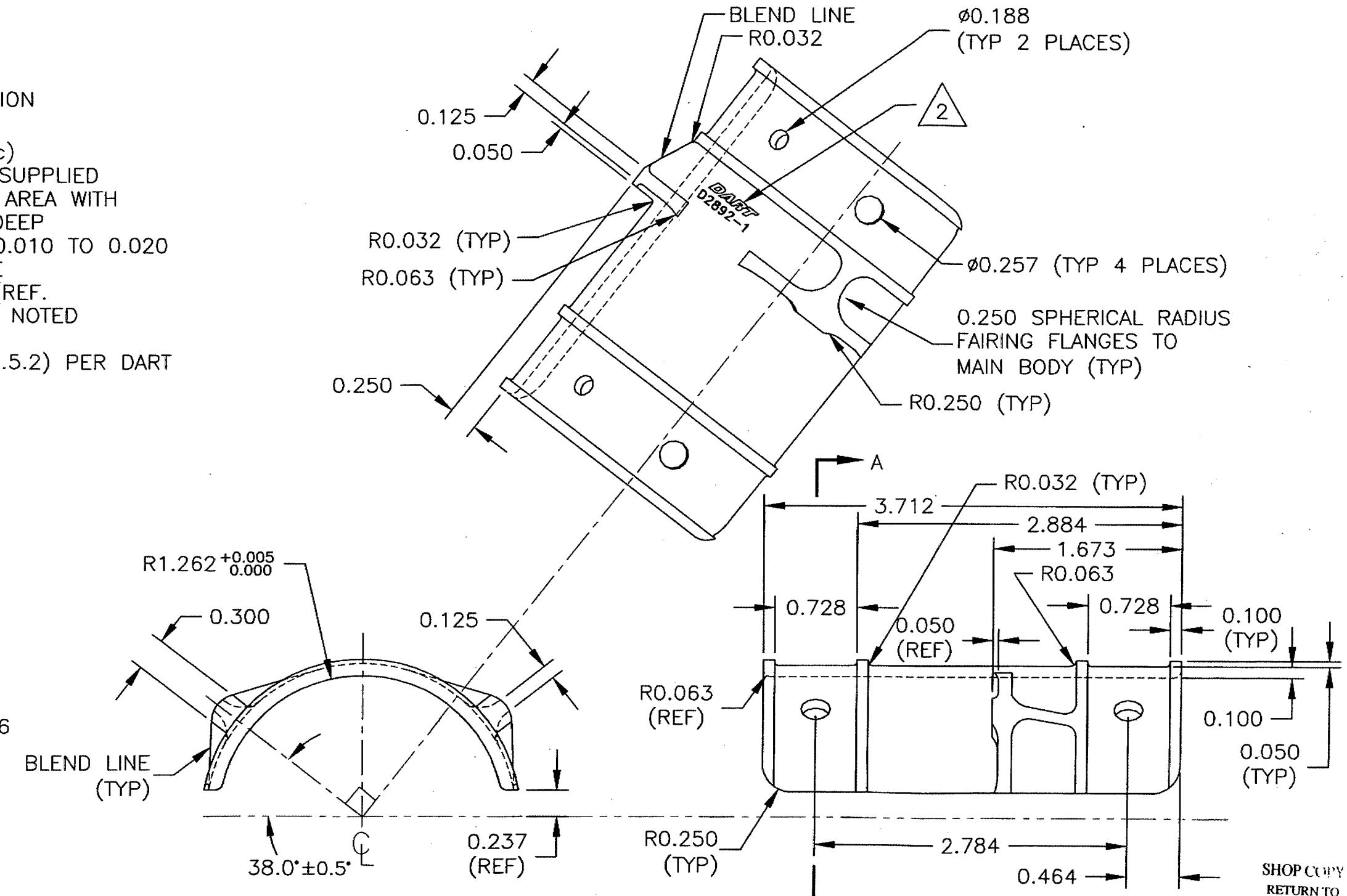
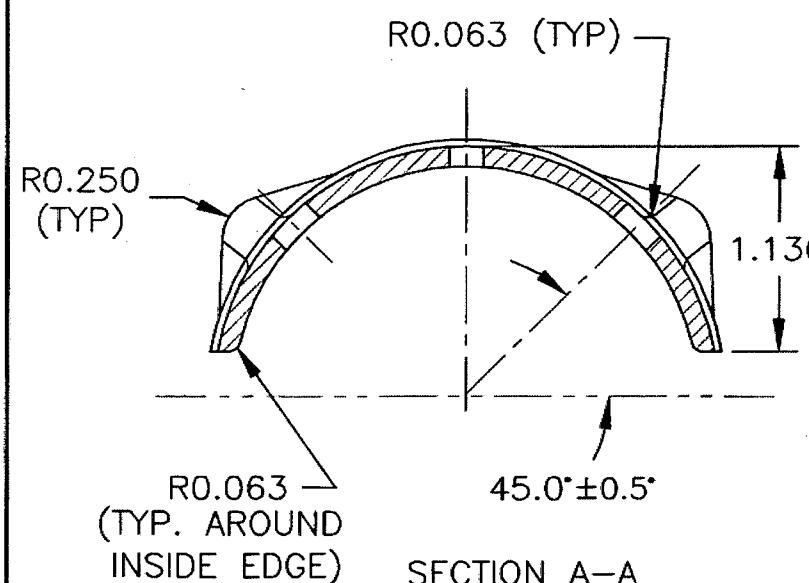
Audited by: SJ Date: 08/12/20

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	<u>JLM</u>

D2892-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010–0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF.  
 $X_{XXX} = \pm 0.010$ ) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



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A	00.11.17	NEW ISSUE
DESIGN	DRAWN BY	DART
CP	CP	DART
CHECKED	APPROVED	DRAWING NO.
CP	CP	D2892
DATE	TITLE	SCALE
00.11.17	Ø2.500 SUPPORT	1:1